

Date: Wednesday, 19/11/2008 9:58:04 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 43539		
Estimate Number	: 10709		
P.O. Number	:	Part Number	: D32101
This Issue	: 19/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3210 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 42025	Drawing Revision	: A
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 25/11/2008
Checked & Approved By	: <u>JLD 08.11.19</u>	Qty:	10
Comment	: Est Rev:A New Issue 05-11-17 JLM	Um:	Each
	: Est Rev:B Now On Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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32



Comment: Qty.: 2.6177 sf(s)/Unit Total: 26.1765 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080) Identify as D3210-1
 Batch: 109242 IB 8-11-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3210
 Dwg Rev: A IB 8-11-25
 Prog Rev: A
 2-Deburr if necessary IB 8-11-25

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-11-25

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/11/25 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

N/A Done at step #2-2 8/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 9:58:04 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43539

Part Number: D32101

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M-h S 6/1/25

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(12x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 08/11/25

8.0

POWDER COATING

POWDER COATING



(12x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:20
01
320
10:50*

M-h 08/11/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/11/26

10.0

PACKAGING 1

PACKAGING RESOURCE #1



(12x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *210*

8/11/27

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3210	REV. A SHEET 1 OF 1
DATE 03.09.03		TITLE DOUBLER	SCALE 1:3
A	03.09.03	NEW ISSUE	

D3210-1 DOUBLER

MAKE PER DRAWING FILE "D3210-A1.DWG"

CHECK PER TEMPLATE D3210-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

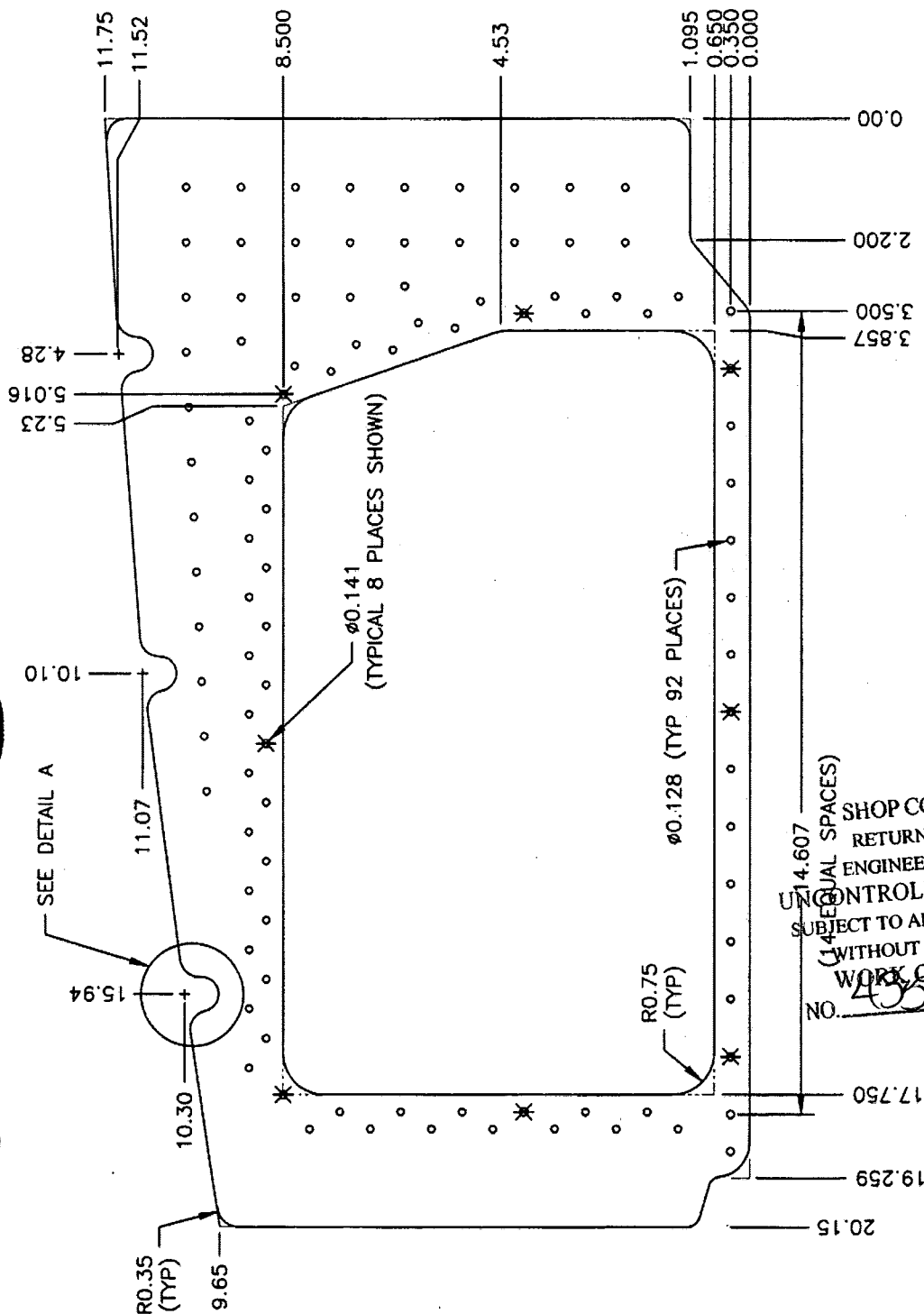
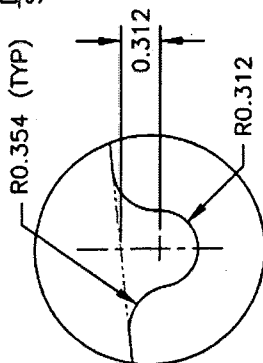
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

DETAIL A
SCALE 2:3



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